

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022927**Date Inspected:** 09-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Steel Barriers & Handrail**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

SMAW welding of weld identified as E2-SB31-004-102, located on Steel Barrier, E2-SB31-004. Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding of weld identified as E2-SB32C-001-101, located on Steel Barrier, E2-SB32C-001. Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding of weld identified as E2-SB34-001-104, located on Steel Barrier, E2-SB34-001. Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding of weld identified as BKR-FS2-3-P-10, located on BKR-FS2-3. Welder is identified as 201861. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to

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comply with WPS-B-T-2112.

SMAW welding of weld identified as BKR-FS2-3-P-10, located on BKR-FS2-3. Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding of weld identified as BKR-FS2-3-P-10, located on BKR-FS2-3. Welder is identified as 068918. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

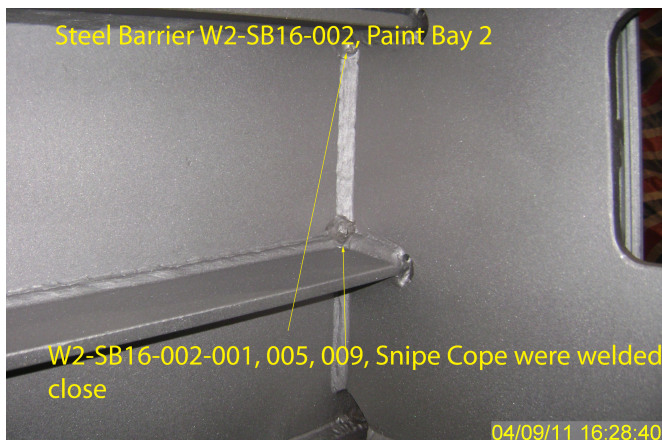
Description of Incident: This QA Inspector was notified by Nace QA inspector Mr. James Lumley during his post blast inspection of Steel Barriers that were in preparation for the painting operation. This QA Inspector arrived at the Paint Shop 2 and discovered the following.

The sniped areas of the rib plate to diaphragm on the Steel Barrier W2-SB16-002 were seal welded which were not in compliance with the correct documents. The area of the snipe access holes shall have an opening of six (6)mm. The welds were identified as W2-SB16-002-001, 002, 003, 004, 005, 006, 007, 008, 009, 010, 011, 012, 032, 033, 034, 035, 036, 037, 038, 039, 040, 041, 042, 063, 064, 065, 066, 067, 069, 070, 071, 072, 073, 074.

The rib plate to front shell plate on Steel Barrier W2-SB24-001, fillet weld is not in compliance with the contract documents. The area of the fillet weld is W2-SB24-001-128, and has excess porosity.

Longitudinal Linear Indication (LLI) located the end of the welds also were visually observed the welds of rib plate to diaphragm on steel barriers identified as W2-SB25-002, E5-SB25-001, E5-SB24-001, W2-SB21-001, W2-SB16-001. These steel barriers were taken back to Bay 16 for repairs.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey, Delbert	Quality Assurance Inspector
Reviewed By:	Hall, Steven	QA Reviewer
